

Date: Thursday, 6/29/2006 3:51:43 PM
 User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : SPACER
 Job Number : 27789
 Estimate Number : 10685
 P.O. Number : N/A Part Number : D34553
 This Issue : 6/29/2006 S.O. No. : N/A Drawing Number : D3455 REV.A
 Prsht Rev. : NC Project Number : N/A
 First Issue : N/A Type : MACHINED PARTS Drawing Revision : A
 Previous Run : 25525 Material : N/A
 Due Date : 7/12/2006 Qty: 20 Um: Each
 Written By : SEE COMMENT BELOW
 Checked & Approved By : 06 06 29
 Comment : EST REV.A 05.11.17 NEW ISSUE EC

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 MDELRLNR1000 Delrin Round Bar 1"



Comment: Qty.: 0.0231 f(s)/Unit Total : 0.2310 f(s)

Delrin round bar 1.00"

(M-DELRIN-R1.000)

Batch: M101078

06/07/06

2.0 HARDINGE HARDINGE CNC LATHE SMALL



Comment: 1-TURN AS PER FOLIO FA584 & DWG D3455,

FOLIO REV: _____

DWG REV: _____

N/A Machined Manually

2-DEBURR AS REQUIRED

06/07/06

20

3.0 QC2 INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

06/07/06

20

4.0 QC8 SECOND CHECK



Comment: SECOND CHECK

06/07/06

20

5.0 SMALL FAB 1 SMALL & MEDIUM FAB RESOURCE 1




Comment: Deburr if necessary.

06/07/06

20

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☐ No ☒ DQA:  Date: 06/07/07

NOTE: Date & initial all entries

QA: N/C Closed: _____ Date: _____

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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SPACER

Job Number: 27789

Part Number: D34553

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

JG 06/07/06 20

7.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: 438

Pc 4/7/7 20

8.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

20 06/07/07

Job Completion



4 06-07-07

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

NOTE: Date & initial all entries

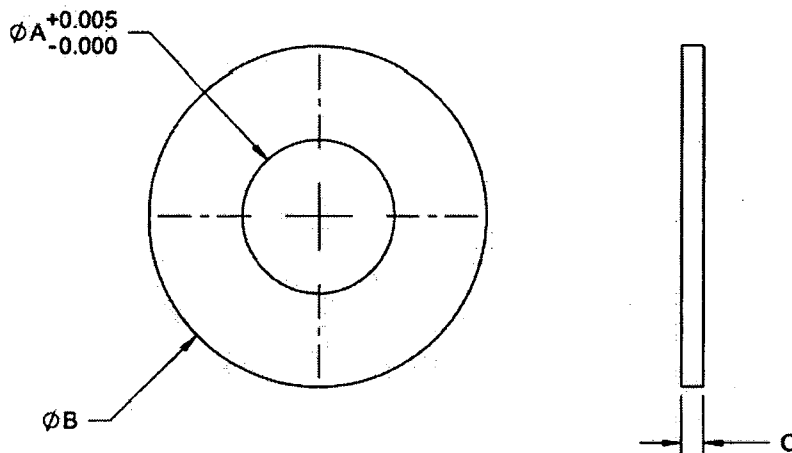
QA: N/C Closed: _____ Date: _____



DESIGN RF	DRAWN BY RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3455	REV. A SHEET 1 OF 1
DATE 05.09.02		TITLE SPACER	SCALE 2:1
A	05.09.02	NEW ISSUE	

RELEASED

05.12.09 *[Signature]*



D3455-X

1) SPECIFICATION: **D3455-X SPACER**

DASH No.

WHERE 'X' IS THE SIZE PER THE FOLLOWING TABLE:

DASH No.	A (in)	B (in)	C (in)
-1	0.453	1.00	0.065
-3	0.386	1.00	0.050

NOTES:

- 1) MATERIAL: DELRIN ROUND BAR (REF. DART SPEC. M-DELRIN-R)
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL UNMARKED SHARP EDGES 0.005 TO 0.010

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. **27789**

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DART AEROSPACE LTD	Work Order:	27789
Description: SPACER	Part Number:	D34553
Inspection Dwg: D3455, Rev: A		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST



X

First Article

X

Prototype

[illegible]

Measured by:		Audited by:	J. G.	Prototype Approval:	
Date:	06/07/06	Date:	06/07/06	Date:	N/A

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	